

Work Order ID 84824

84824

Page 1

May-23-12 4:14:39 PM

Item ID: **D4277-1**

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 23/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MJS*

Date: *12/05/23*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4277

D

100

0.00

100

Large Fab

Large Fab

Memo

D4277

0.00

1- Cut tube as per dwg D4034
2- Drill and chamfer holes on both side use DT9715
3- Remove marking
4-Deburr

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: *WA*

0.00

120

Packaging

Memo

0.00

Packaging

STOCK IN BASKET CELL

10

CC 12-6-13
DL 12-6-13

Cpl 12-06-13 10x

10x Cpl 12-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

84824

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 23/05/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 30/05/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/6/18 ~~78~~

MS
12-06-15

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NOTE: Date & initial all entries

Picklist Print

May-23-12 4:14:43 PM

Page 1

Work Order ID: 84824

84824

Parent Item: D4277-1

D4277-1

Parent Item Name: Rib

Start Date: 23/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.11.12 new issue DD verf:EC

IPP Rev:B

11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:C 11.03.03

AS PER DWG REV.D DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	71.0989	2.0833	2.192947			

M304TS0 750W 049

**

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

70.03639585

M 12/898 →

~~13.152~~

~~20.833~~

21.9395

119147

2

119643

3.30639585

121439

64.73

WA034

1.0625

121087

1.0625

(10)

DL 12-6-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 84824 MLJ
12/05/23

D4277-1 RIB

D4277-3 RIB

D4277-5 RIB

D4277-7 RIB

D4277-9 RIB

D4277-11 RIB

D4277-19 RIB

RELEASED
 2011-02-24
 MD

D	CHANGED ANGLE FROM 71° TO 61° (B3-3)	SC	11.02.09
C	D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1	SC	10.12.23
B	RMV -13/-15/-17 (OBSOLETE); -3: 6.09 WAS 20.25 (C5-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 26.25 (B5-2)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4277 REV. D SHEET 1 OF 3 TITLE RIBS SCALE NTS DATE 11.02.09 <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			

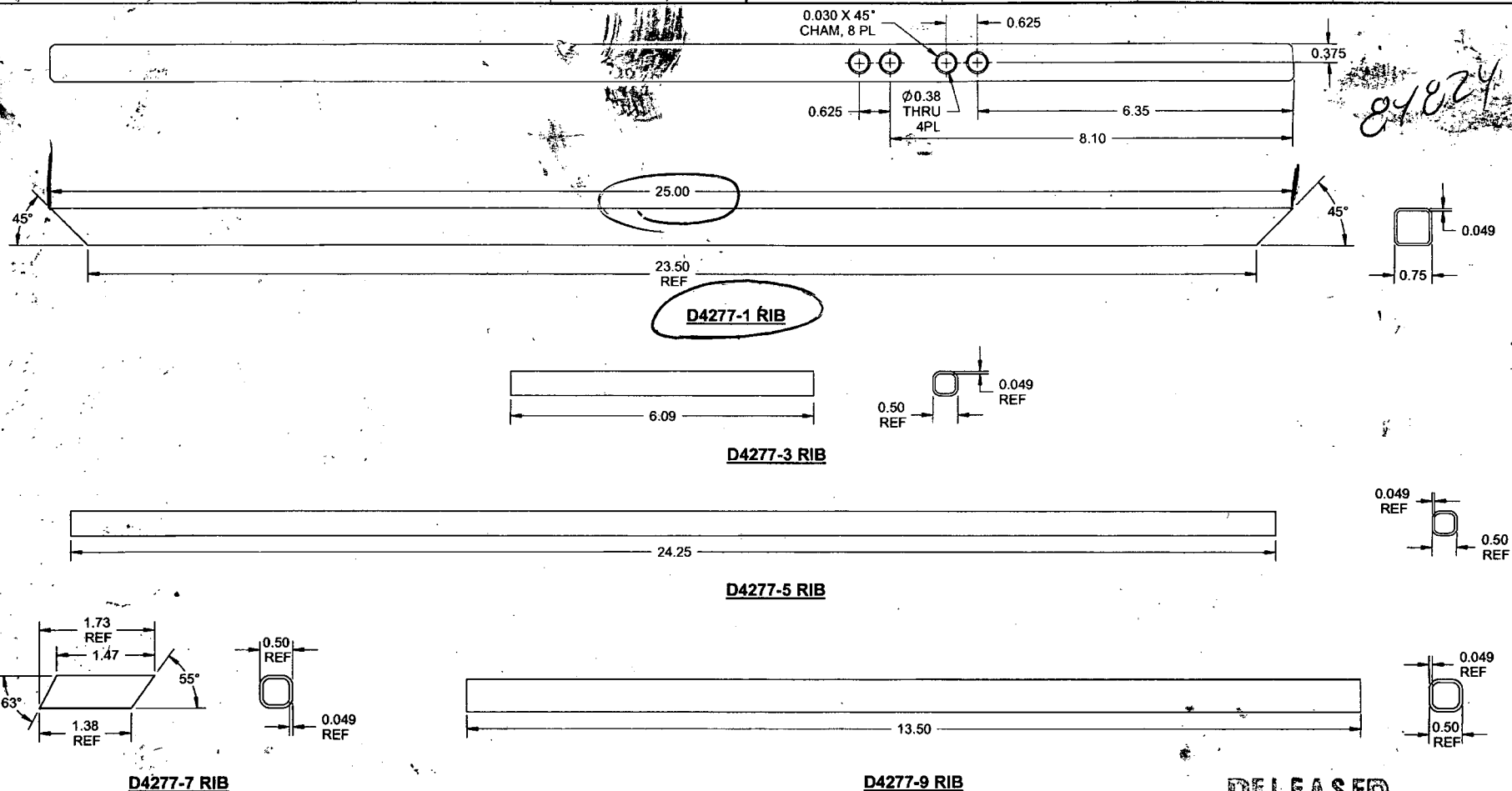
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL
 - 1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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2011-02-10

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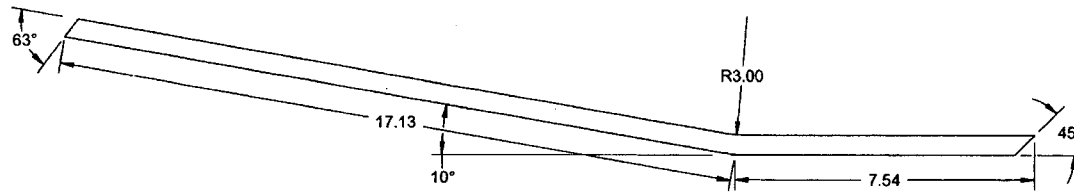
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

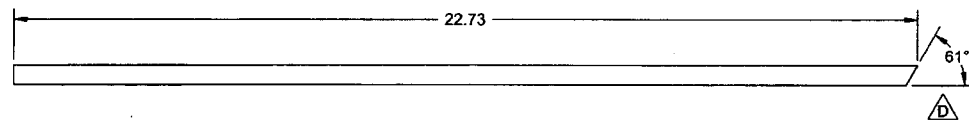
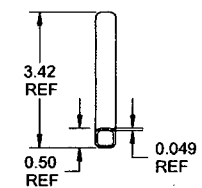
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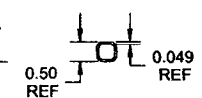
84824



D4277-11 RIB



D4277-19 RIB



NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

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2011-02-24

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